

Split

Work Order ID 100773-2

100773

Item ID: D4543-4
Revision ID:
Item Name: Retainer, Outer, RH
Start Date: 5/09/13 Start Qty: ~~30.00~~ *30*
Required Date: 5/09/13 Req'd Qty: 30.00 *30*
Reference:

Accept *N9000040100* Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan: *HP* Date: *13-05-1*
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Seq#	Work Center ID	Description	Run Hours	Seq ID	Lot #	Plan Code	Accept Qty	Reject Qty	Reject Number	Inspr. Stamp
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Draw Nbr	Revision Nbr
D4543	B

100	0.00
100	0.00

Waterjet
FLOW CNC Waterjet
Memo
1- Cut D4543-3E as per dwg
Prog rev: *B*
Dwg rev: *B*
2- Deburr

30 0 JM3-6-3

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110	QC	0.00
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Quality Control

30 0 JM3-6-3

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Item ID: D4543-4

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Retainer, Outer, RH

Stop

NS2

Start Date: 5/09/13

Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/09/13

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Source ID:
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Memo

0.00

130

Small Fab

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

0.00
DAS
27
0.00
136.4

30

8

8
13/06/07

0.00
DAS
27
0.00
136.7

8

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Item ID: D4543-4

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Retainer, Outer, RH

Start Date: 5/09/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/09/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

8 13-6-7

13-6-7

8

87528

8x

80
13-6-7

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Item ID: D4543-4

Accept

Revision ID:

N900040100

Setup Start ***NS1***

Item Name: Retainer, Outer, RH

Stop ***NS2***

Start Date: 5/09/13 Start Qty: 30.00

30

Required Date: 5/09/13 Req'd Qty: 30.00

30

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC21- Final Inspection - Work Order Release

0.00

180

QC

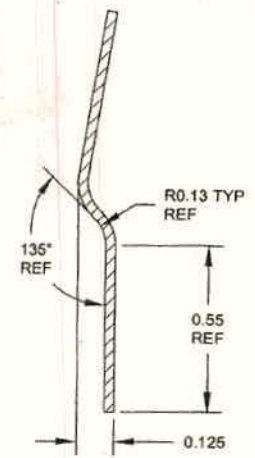
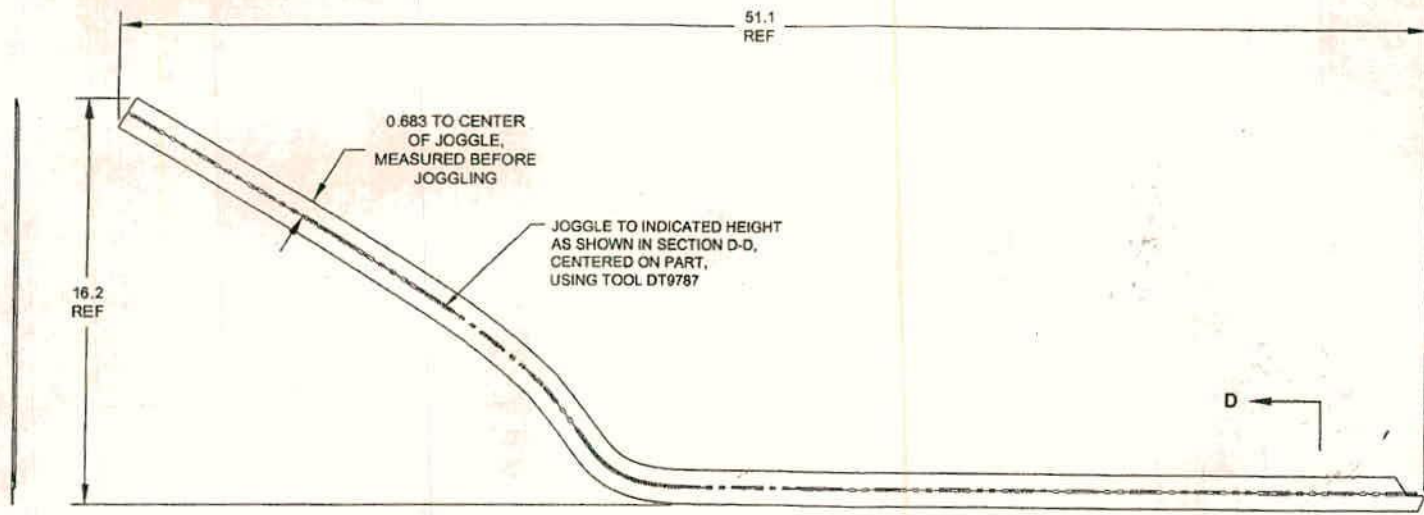
Memo

0.00

Quality Control

13/6/11 *[Signature]* ME
13-6-10

100773 MLS
13-06-04



SECTION D-D
JOGGLE DETAIL
SCALE 12X

D4543-4 RETAINER, RH OUTER
(SIDE/TOP) B

RELEASE
2013-04-22

- NOTES:**
- 1) MATERIAL: MAKE FROM D4543-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.24 lbs

DESIGN	<i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>P</i>		
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>ML</i>	D4543	SHEET 5 OF 8
APPROVED	<i>ML</i>	TITLE	SCALE
DE APPR.	<i>ML</i>	RETAINER, OUTER	NTS
DATE	13.04.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	